

Date: Tuesday, 7/1/2008 2:35:20 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL LOCK COVER
Job Number : 40206	
Estimate Number : 10445	
P.O. Number :	Part Number : D33683
This Issue : 7/1/2008 S.O. No. :	Drawing Number : D3368 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 37186	Material :
Written By :	Due Date : 7/30/2008 Qty: 10 Um: Each
Checked & Approved By : <u>08.07.01</u>	
Comment : Est. A 05.01.27 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2000X02000 6061-T6 Bar 2.0" x 2.0"



Comment: Qty: 0.9277 f(s)/Unit Total: 5.5661 f(s)  
Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)  
(M6061T6B2.000x02.000)  
Batch: M13085

NA

08/07/10

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Machine D3368-3 as per Folio FA500 and Dwg D3368  
Identify as D3368-3  
Deburr

SA

08/07/13

(10)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/07/13

(10)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S.F. 08/07/14

(10)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

24/08/07

(10)

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

M18052

START TIME: 8:00 AM

SA

08-07-15

210

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:35:20 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK COVER

Job Number: 40206

Part Number: D33683

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 320°F  
FINISH TIME: 8:30am

*JJ*

08-07-05

PTO 20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57491

Pc 8/2/15

(10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/15 *JJ*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08-07-15	6.1	QC-3 Powder Coating Chemical Conversion inspection permanent change	M/A	08/07/15	10	08.07.15	08/07/15	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40206
<b>Description:</b> Pedal Lock Cover		<b>Part Number:</b> D3368-3
<b>Inspection Dwg:</b> D3368	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

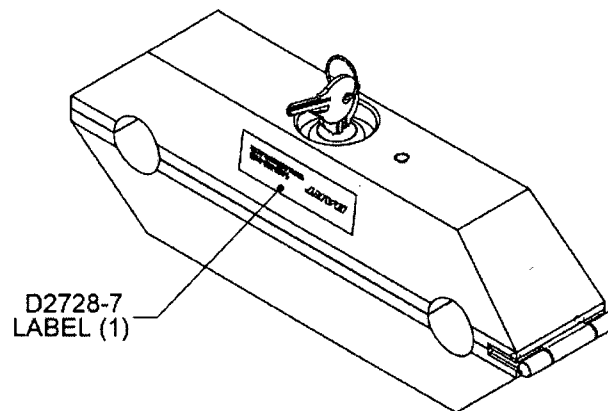
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	+/-0.030	10.258	/			
7.250	+/-0.010	7.250	/			
0.650	+/-0.010	.649	/			
0.107	+/-0.010	.110	/			
1.800	+/-0.010	1.800	/			
45°	+/-0.5°	45°	/			
<del>Ø0.201</del>	<del>+/-0.010</del>	<del>Ø0.201</del>	<del>/</del>			
Ø1.300	+/-0.010	Ø1.279	/			
Ø1.400	+/-0.010	Ø1.400	/			
Ø1.031	+/-0.010	Ø1.029	/			
0.250	+/-0.010	.245	/			
1.500	+/-0.010	1.500	/			
1.440	+/-0.010	1.435	/			
2.00	+/-0.030	1.999	/			
7°	+/-0.5°	7°	/			
0.635	+0.010/-0.000	.640	/			
Ø1.250	+/-0.005	Ø1.245	/			
0.250 deep	+/-0.010	.255	/			
1.000	+/-0.010	1.000	/			
1.450	+/-0.010	1.450	/			
0.375	+/-0.010	.375	/			
0.310	+/-0.010	.310	/			
Ø0.750	+0.010/-0.000	Ø0.754	/			
<del>Ø0.136</del>	<del>+/-0.010</del>	<del>Ø0.136</del>	<del>/</del>			
Ø0.185	+0.005/-0.000	Ø0.187	/			

<b>Measured by:</b> SA	<b>Audited by:</b> J.F.	<b>Prototype Approval:</b> N/A
<b>Date:</b> 08/07/13	<b>Date:</b> 08/07/14	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Dimensions and tolerances changed	KJ/JLM	

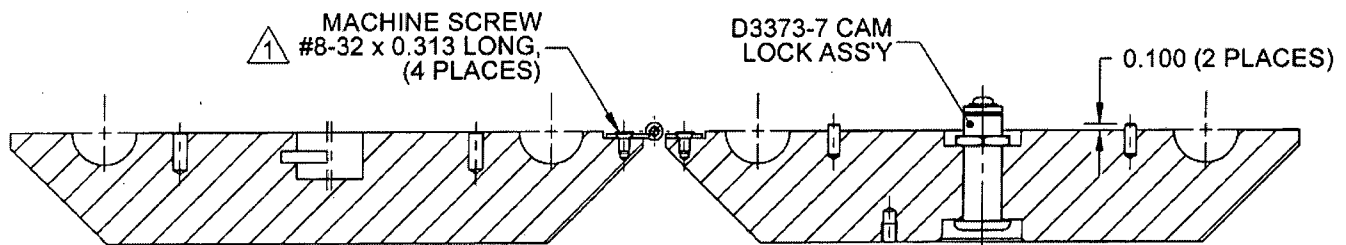


DESIGN 43	DRAWN BY 43	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED JST	APPROVED [Signature]	DRAWING NO. <b>D3368</b>	REV. B SHEET 1 OF 3
DATE <b>05.03.22</b>		TITLE <b>PEDAL LOCK</b>	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

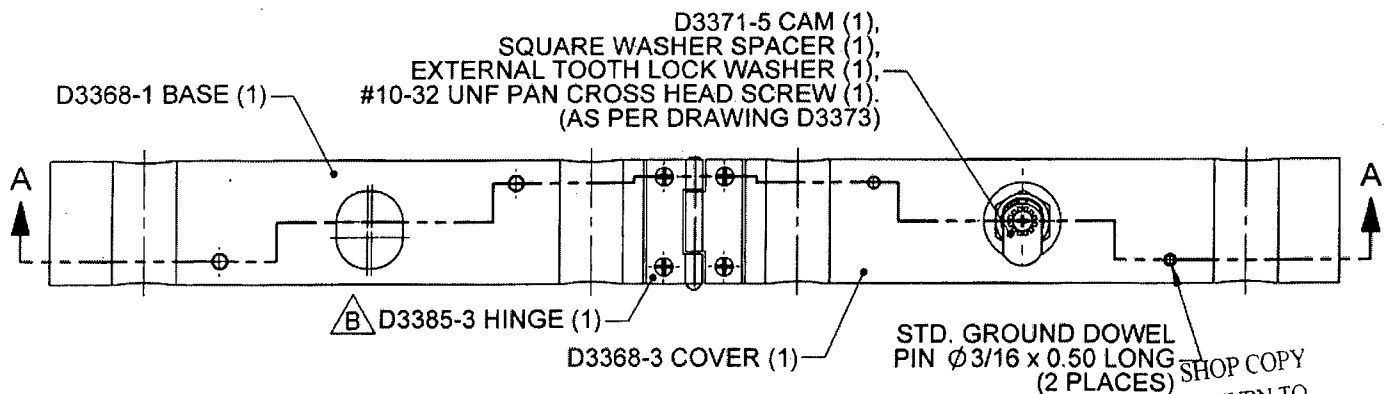


**RELEASED**  
25/04/28

**PEDAL LOCK SHOWN LOCKED WITH KEY**



**SECTION A-A**



**D3368-051 PEDAL LOCK ASSEMBLY**

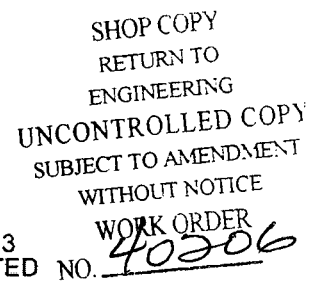
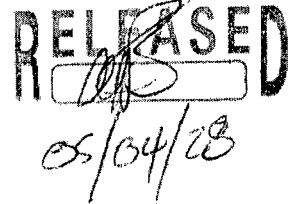
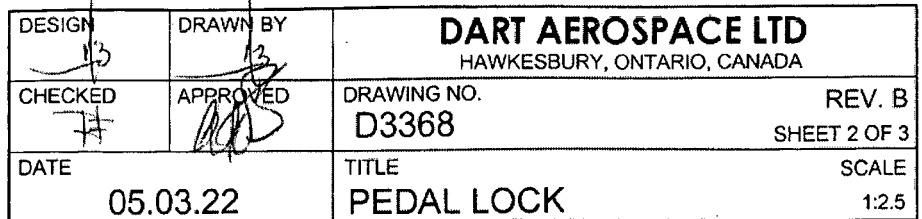
**NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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**NOTES:**

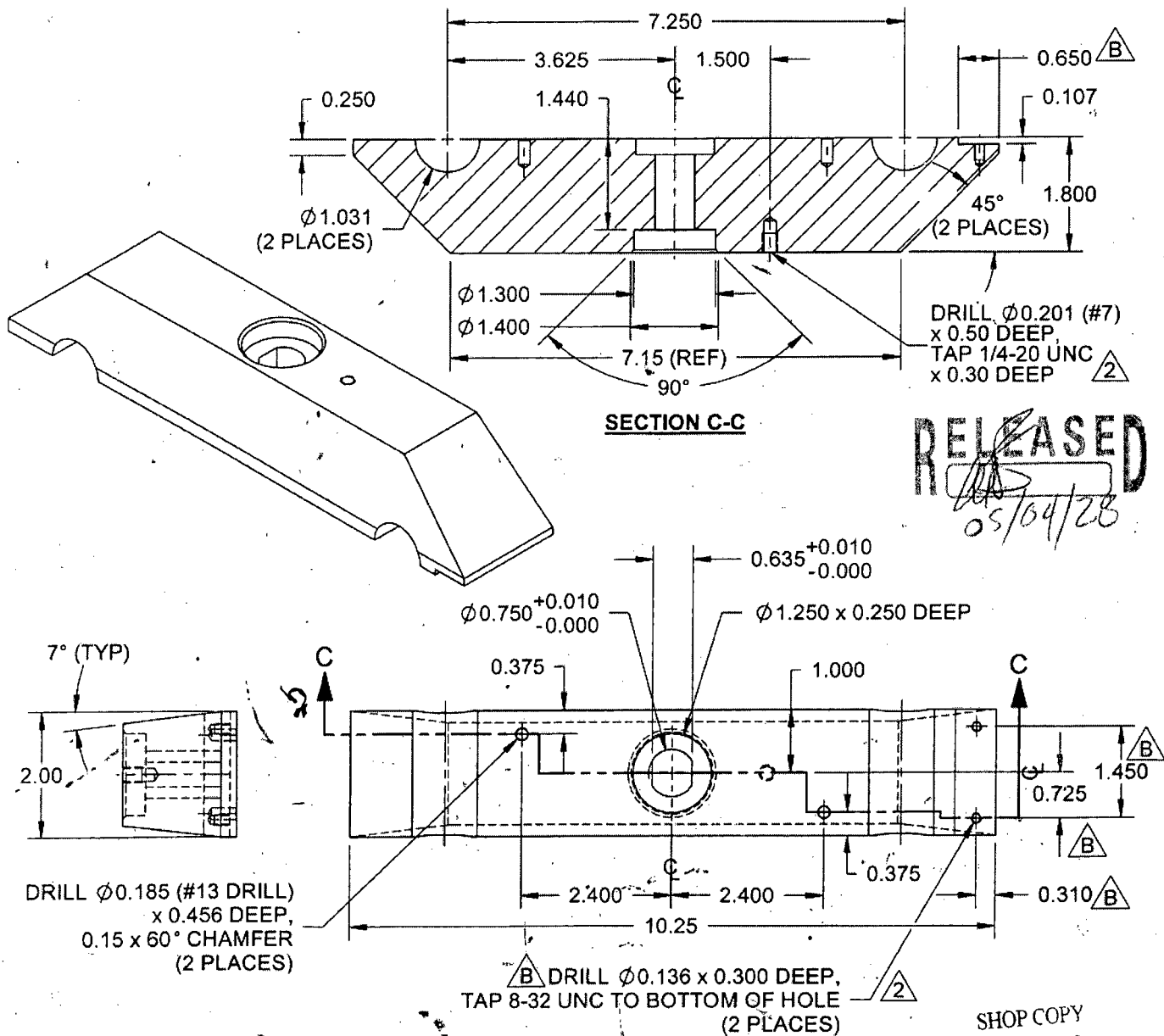
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3368</b>	REV. B SHEET 3 OF 3
DATE <b>05.03.22</b>	TITLE <b>PEDAL LOCK</b>	SCALE 1:2.5	

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
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